

Date: Monday, 26/05/2008 1:12:04 PM
 User: Linda Lacelle

Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: FITTING
Job Number	: 39486		
Estimate Number	: 13336		
P.O. Number	:	Part Number	: D37621
This Issue	: 26/05/2008 S.O. No. :	Drawing Number	: D3762 PROTO
Prsht Rev.	: NC	Project Number	: IA0004
First Issue	: 11 Type : R&D MACHINED PARTS	Drawing Revision	: PROTO 08.05.29
Previous Run	:	Material	:
Written By	: <u>08.05.27</u>	Due Date	: 02/06/2008 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-05-23 new issue DD verified by:JLM		

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1680 f(s)/Unit Total: 1.0080 f(s)
 ROUND BAR 1.00"
 batch: 218147

RP 08/05/28

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA748 Rev: proto & Dwg D3762 Rev: proto

8

2-Deburr per dwg D3762

RP 08/05/28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RP 08/05/28

4.0	QC8	SECOND CHECK
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ENGINEERING APPROVAL

Comment: SECOND CHECK

RP 08.05.30 RP 08.05.29

(8)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

dp.

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FITTING

Job Number: 39486

Part Number: D37621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

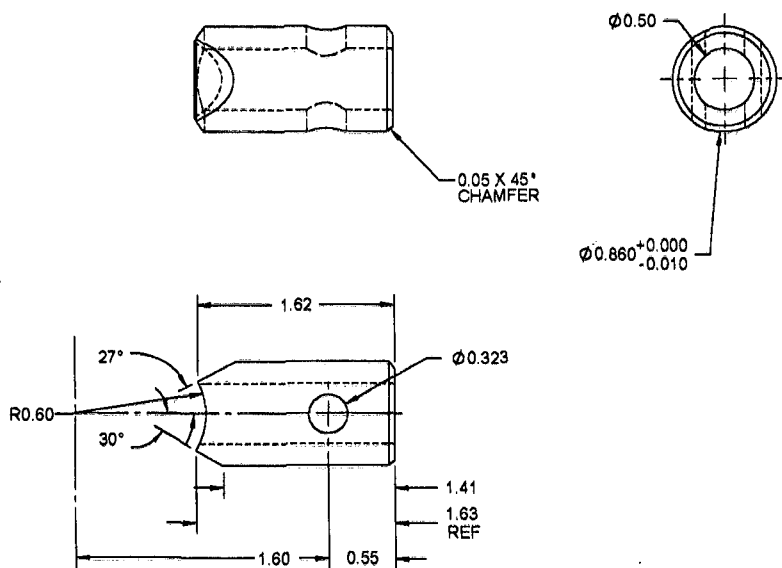
08-06-02 Prototype

Job Completion



Chap To w/o 00196.

08-06-11



D3762-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (AMS-QQ-A-200/8 OR AMS-QQ-A-225/8) ALUMINUM BAR (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3762	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FRONT LEG FITTING	1:1
DATE	08.05.29	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

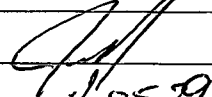

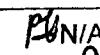
PROTOTYPE
08.05.29

DART AEROSPACE LTD		Work Order: 39486
Description: Crosstube Assembly		Part Number: D3762-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.55	+/-0.30	.544	✓			
	Ø.323	+0.006 -0.000	Ø.326	✓			
	1.62	+/-0.30	1.611	✓			
	Ø.860	+0.010 -0.000	.855	✓			
	Ø.50	+/-0.30	.5005	✓			
	.050x45°	+/-0.10	.041x.45°	✓			
	R.600	+/-0.30	R.600	✓			
SIDE B							

Measured by: 	Audited by: 	Prototype Approval:  N/A
Date: 08-05-29	Date: 08-05-29	Date: 08-05-29 N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 05/07/25
Supplier: Copper & Brass

Batch No: M18147
Dart P/O: 2008385

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☒ No ☐
Q.C. Inspection [Signature]

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606176B2.00x4.00		24	12		12	

TSR No. _____

Initials of receiver (if shipment OK) DC

Production/Admin: _____
Date: 05/07/28
Received/Costing: 2-1385
Initial: AS
H:\ISO9000\Forms\Purchase\RECREPORT rev B

Accounting: _____
Date: _____
AP/MR: _____
Initial: _____

NO PROCESSING - 300" ML

ACCT. # <u>12006</u>
ACCT. NAME _____
POSTAL CODE _____
ADDRESS _____

GST/HST

2.80

PLEASE REMIT IN CANADIAN FUNDS

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH. PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

TOTAL \$

42.8

REMIT BY:

08/17/05

TERMS: NET 30 DAYS

KAISER ALUMINUM
MATERIAL CERTIFICATION
COPPER & BRASS SALES
6905 KENDERRY GATE UNIT 4
MISSISSAUGA, ON L5T2Y8

PAGE

KAISER ALUMINUM
S 74 E Ave
Mississauga, OK 74145

COPPER & BRASS SALES

SOUTHFIELD MI 48086 C94583

SOLD TO PURCHASE ORDER

08/17/04

DATE PRINTED

SOLD TO

PURCHASE ORDER

DATE PRINTED

018542-1

1.000 PRECIS ROD +/- .004 TOL

CUSTOMER PART NUMBER

DESCRIPTION

801378-001

503A 206

6061-T6511B

RELEASE-ITEM

LOT

ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEN
503A 206	0001 0001	53.8	51.0	11.9		N/A	N/A
503A 206	0001 0002	53.5	50.6	11.8		N/A	N/A
503A 206	0001 0003	53.6	50.6	11.9		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Other
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05 0.1
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00 0.0

APPLICABLE REQUIREMENTS:

PER ASTM-B221-02, STENCILED
ASME-SB221 1998 SECT II
PER AMS-QQ-A-200/8
UNS#6061
MEETS ALL SPECIFICATION
REQUIREMENTS FOR 6061-T6511
ELEVATED MINIMUM MECHANICAL
PROPERTIES AS FOLLOWS:
UTS=42.0 KSI MIN
YIELD=38.0 KSI MIN
ELONGATION=10.0% MIN

Kaiser Aluminum & Chemical Corp. ('Kaiser')
hereby certifies that metal shipped under
this order has been inspected and tested
and found in conformance with the applicable
specifications forming a part of the descrip-
tion set forth in Kaiser's sales acknowledge-
ment form. Any warranty is limited to that
shown on Kaiser's general terms & conditions
of sale. Test reports are on file, subject
to examination.